

Work Order ID 87044

Tuesday, July 10, 2012 1:02:05 PM

87044

Page 1

Item ID: D4061-1

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ski Cushion

Start Date: 7/10/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-07-10* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4061	B
-------	---

100

0.00

100

Mill Conv

Conventional Milling Machine

Memo

1-Turn as per folio FA914 & dwg

FOLIO REV: _____

DWG REV: _____

2-Deburr as required

Manual

0.00

*12-07-16**7*

110

QC2- Inspect parts off machine FA1/FA1B

0.00

110

QC

Quality Control

Memo

0.00

*12-07-17**7*

Work Order ID 87044

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Page 2

Item ID: D4061-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Ski Cushion

Stop ***NS2***

Start Date: 7/10/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
14
9-89

12/07/17

7

8

130

Identify as per dwg & Stock Location: **ST 449** 0.00***130***

Packaging

Memo

0.00

Packaging

7x

80
12-7-17

140

QC21- Final Inspection - Work Order Release 0.00

140

QC

Memo

0.00

Quality Control

12/7/19

mf
12-07-18

Picklist Print

Tuesday, July 10, 2012 1:02:05 PM

Page 1

Work Order ID: 87044

Parent Item: D4061-1

Parent Item Name: Ski Cushion

Start Date: 7/10/2012

Required Date: 7/19/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE JLM 10-02-18 VERIFIED BY:EC IPP REV:B 11.01.10 AS PER
DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	3.2000	0.4125	4.3421053			
UHMW U-Channel													

Location

MAT055

70348

Loc Qty

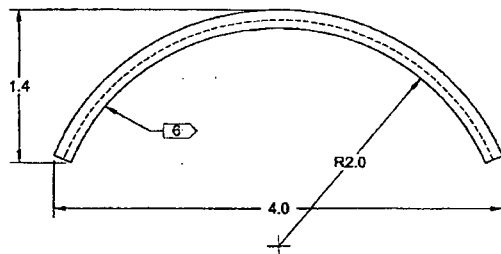
3.2

3.2

Loc Code

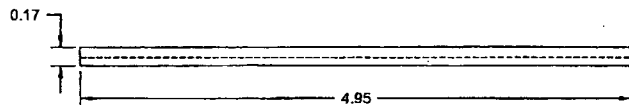
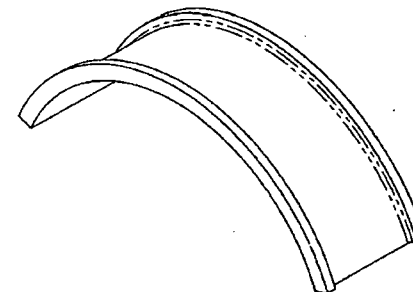
3.2

PA 12-07-16

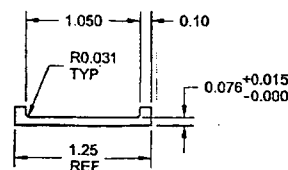


D4061-1 412 SKI CUSHION
(MAKE FROM D4061-1F)

87044



D4061-1F FLAT MACHINED STATE



RELEASED
2010-12-23
MR

NOTES:

- 1) MATERIAL: MAKE FROM D4287-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4061-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS. PART NOW MACHINED FLAT AND SHAPED WITH ADEQUATE RADIUS. REF: PAR10-28.	MB	10.12.07
A	NEW ISSUE	MB	10.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D4061

TITLE

412 SKI CUSHION

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REV. B

SHEET 1 OF 1

SCALE

NTS

FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	11.02.11	New Issue	KJ	

Work Order ID 70348

Friday, June 03, 2011 10:11:05 AM



Page 1

Item ID: D4287-3

Accept



Setup Start



Revision ID:

Stop



Item Name: UHMW U-Channel

Start Date: 6/3/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start

Approvals: Process Plan: CL Date: 11/06/03 Tooling:

Date:

Stop



QC: _____ Date: _____ SPC (Y/N): _____

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4287

A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 14237

Material: UHMW (white)

Supplier P#: McMaster-Carr 8672K31

Material release note required

CL 11/06/03 20ft

110

0.00



Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

Packaging

Packaging (20)

120

0.00



QC

QC6- Inspect dimensions to drawing

Memo

0.00

Quality Control

8 1/2" x 1/2" x 1/2"*2 length @ 10'

Work Order ID 70348

Friday, June 03, 2011 10:11:05 AM

Page 2

Item ID: D4287-3

Accept

Setup Start

Revision ID:

Stop

Item Name: UHMW U-Channel

Start Date: 6/3/2011 Start Qty: 20.00

Required Date: 6/7/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 489A

0.00



Packaging

Memo

0.00

Packaging

4/6/7 *[Signature]*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/6/7 *[Signature]**[Signature]* 11-06-7
(20)

Picklist Print

Friday, June 03, 2011 10:11:03 AM

Page 1

Work Order ID: 70348

Parent Item: D4287-3

Parent Item Name: UHMW U-Channel




Start Date: 6/3/2011

Required Date: 6/7/2011

Start Qty: 20.00

Required Qty: 20.00

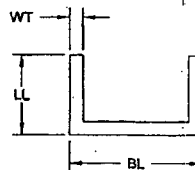
Comments: IPP Rev:A 10.11.15 new issue DD Verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
8672K31  UHMW U-Channel		Purchased	No			110	f	0.0000	1	20			



Page 1 of 1

SPECIFICATION CONTROL DRAWING



D4287-X UHMW U-CHANNEL

DART PART NUMBER	POSSIBLE SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	PURCHASED LENGTH	BASE LENGTH (BL)	LEG LENGTH (LL)	WALL THICKNESS (WT)	WEIGHT (lbs)
D4287-1	McMASTER-CARR	9928K53	UHMW (WHITE)	96.0	1.05	0.75	0.250	2.11
D4287-3	McMASTER-CARR	8672K31	UHMW (WHITE)	96.0	1.25	0.75	0.125	1.29

C21106103
W10: 70348

RELEASED
2010-11-03
JW

NOTES:

- 1) MATERIAL: PURCHASE PER TABLE
OR
UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF. DART SPEC. MUHMW
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

A	NEW ISSUE	MB	10.10.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	DSC-D4287	SHEET 1 OF 1
TITLE	UHMW U-CHANNEL	SCALE
		NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14237

Purchase Order Date 6/3/2011

PO Print Date 6/3/2011

Page Number 1 of 1

Order From :

VU-MCM001

MCMaster-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

Contact Name

Vendor Phone 330 995 5500

Vendor Fax 330 995 9600

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

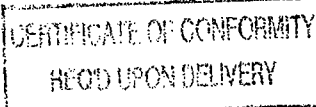
Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

6/11/10/103

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	8672K31	UHMW U-Channel	6/7/2011 Yes	20.00 f	Purolator ground	\$2.3900	\$47.80
		Special Inst: AS PER DWG D4287 REV. A B70348 MCMaster P/N: 8672K31 WHITE UHMW CHANEL 1" IN 5FT LENGTH X 4 = 20FT					
2	6718K52	Fitting, Quick Disconnect	6/7/2011 Yes	8.00 Each	Purolator ground	\$4.7600	\$38.08
		Special Inst: AS PER DWG D4182 REV. A B70316 MCMaster P/N: 6718K52					
3		91458A170 262 10ML LOCTITE	6/7/2011 Yes	3.00 Each	Purolator ground	\$12.3900	\$37.17

Deliver To: SYLVIE



PO Total:

\$123.05

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 6/3/2011



200 Aurora Industrial Parkway
Aurora OH 44202
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K1
Canada

Purchase Order
PO14237

McMaster-Carr Number
7773000-01

Page 1 of 1

06/03/2011

Line	Description	Ordered	Shipped
1	8672K31 Wear-Resistant UHMW Polyethylene Edge Trim, U-Shaped, 1-1/4" Base X 3/4" Legs, 10' L	20 Feet	20
	Unit Price:	\$2.39	
	Extended Price:	\$47.80	

Sub 6666

7 - 130 - 05 27 - 08 K86 2 LG 1

Shipped separately from our Cleveland warehouse on 06/03

2	6718K52 Stainless Steel Industrial-Shape Hose Coupling, Plug, 1/4" Nptf Female, 1/4 Coupling Size	8 Each	8
3	91458A170 Loctite 262 Threadlocker Adhesive, .34 oz, Red	3 Each	3

Charges for this shipment

Merchandise Amount: \$47.80
Sales Tax: \$2.39
Total: \$50.19

Dart Aerospace Ltd

EXP
INV

Fr

3 lbs
1 line

FW1FSP06
06/03/2011
10:25/10:52
234
Cycle 27

85-0-3707

